












Date: Wednesday, 28/01/2009 4:59:42 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING*
Job Number	: 45318		
Estimate Number	: 10725		
P.O. Number	:	Part Number	: D2652
This Issue	: 28/01/2009 S.O. No. :	Drawing Number	: D2652 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 44278	Material	:
Written By	:	Due Date	: 10/02/2009 Qty: 300 Um: Each
Checked & Approved By	: <u>JUD 09.01.29</u>		
Comment	: Est Rev:B 02.06.13 Now machined in house. NG		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0500	303 Round Bar 0.500"	
			
Comment: Qty.: 0.0578 f(s)/Unit Total : 17.3250 f(s) Material: 303 ss .500" Round Bar (M303R0500) Batch: <u>M110252</u> <u>09/01/30/gml</u> <u>09/01/31</u> <u>309</u>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652  FOLIO REV: <u>AA</u> DWG REV: <u>A</u>  2-DEBURR AS REQUIRED <u>gml 09/01/31</u> <u>309</u>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>gml 09/01/31</u> <u>309</u>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <u>SA 09/01/31</u> <u>309</u>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>SA</u> <u>9/2/2</u> <u>SP</u>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 45318

Part Number: D2652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 JH

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-02-02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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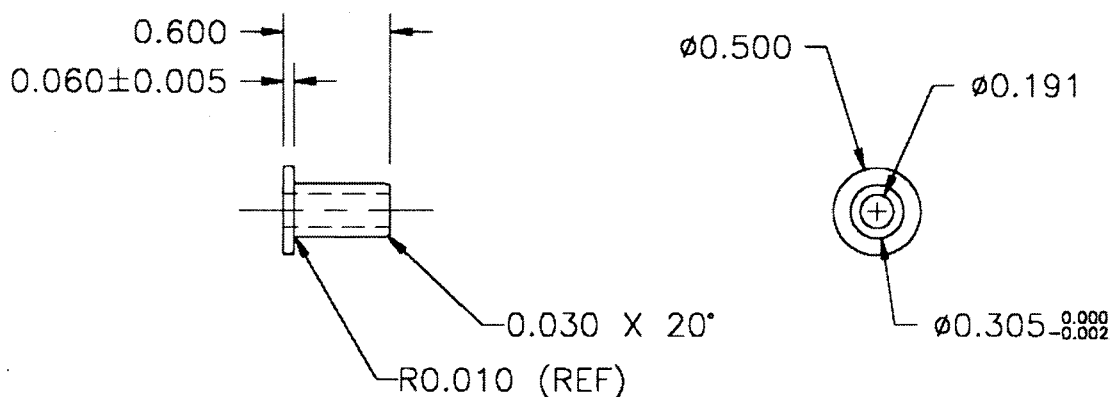
**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2652	REV. A SHEET 1 OF 1
DATE 97:03:25		TITLE BUSHING	SCALE 1:1

RELEASED  
97/04/25 DS



MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QST 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 65318